

Ship 28-31/08

Work Order ID 51682

August 27, 2009 9:22:05 AM



Item ID: D3880-041
Revision ID: A
Item Name: Spacer Assembly

Accept



Setup Start



Stop



Start Date: 8/27/09 Start Qty: 8.00



Required Date: 8/28/09 Req'd Qty: 8.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100



Bandsaw

Jeaspa Bandsaw

8P 09/08/24

Memo

Cut blank per dwg to make D3880-1

0.00

0.00

110



Mill Conv

Conventional Milling Machine

Manufacture as per dwg

8P 09/08/24

Memo

(Make D3880-1)

0.00

0.00

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

8P 09/08/24

0.00

0.00

2) 8/21/08



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Memo

1- C'sink as per Dwg

2-Deburr

3-Assemble as per Dwg

0.00

0.00

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

Small Fab

Assemble per dwg

09/08/31

QC5

09/08/31

09/08/31

09/08/31

09/08/31

09/08/31

09/08/31

09/08/31

09/08/31

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Page 3

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Required Date: 8/28/09 Req'd Qty: 8.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: Date:
QC: Date:

Tooling: Date:
SPC (Y/N): Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Handwritten initials

09/08/31

8 0

170

Identify as per dwg & Stock Location: 139

0.00



Packaging

Memo

0.00

Packaging

Handwritten signature and date 9/12/31

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Handwritten signature and date 09/08/31

Handwritten signature and date 09.08.31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 27, 2009 9:22:04 AM

Page 1 / 2

Work Order ID: 51682

Parent Item: D3880-041RevA

Parent Item Name: Spacer Assembly

Comments:

Start Date: 8/27/09

Required Date: 8/28/09

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6TS0.750W.06 2		Purchased	No			100	f	315.9300	4.0000			



6061-T6 SQ Tube .75 x .75 x .062W

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

315.93

103069

147.94

104422

115.25

16441

18.74

9671

34

130

Each

169.0000

40.0000

MS21069L3

Purchased

No



ANCHOR NUT

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

169

102587

24

103447

125

112314

20

8/28/09/28

1.0

8/30/09/08/31

13
27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Comments:

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Required Date: 8/28/09

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
CCR264SS3-2		Purchased	No			130	Each	358.0000	80.0000			
												
Rivet, Cherry												

Ep 509/08/31

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	358	
108688	62	
108738	196	
112314	100	

80

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

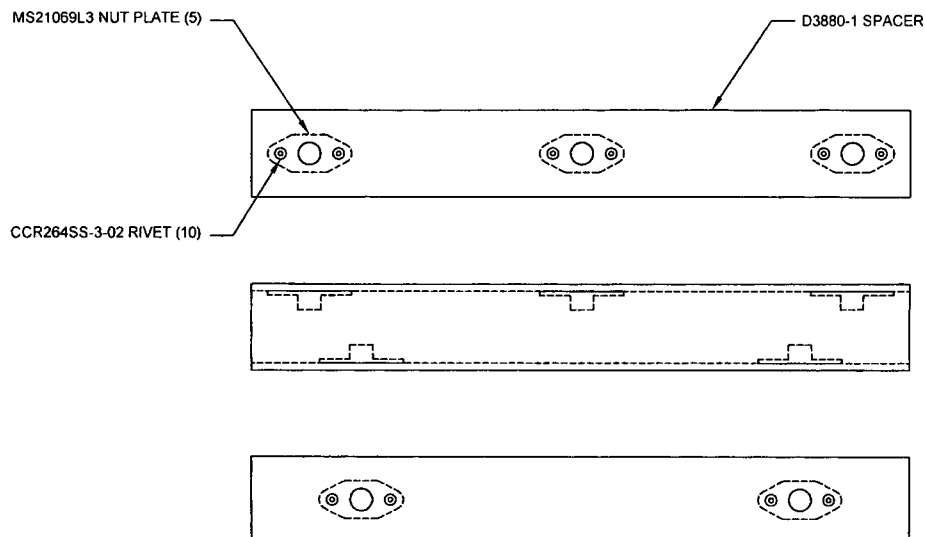
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D3880-041	SPACER ASSEMBLY
2	5	MS21069L3	NUT, SELF-LOCKING PLATE
3	10	CCR264SS-3-02	RIVET, NUT PLATE
4	1	D3880-1	SPACER



D3880-041 SPACER ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3880-041" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.21 LBS

A	NEW ISSUE	KB	09.01.22
REV.	DESCRIPTION	BY	DATE
DESIGN	KB		
DRAWN	KB		
CHECKED	KB		
MFG. APPR.	DD		
APPROVED	KB		
DE APPR.	KB		
DATE	09.01.22		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

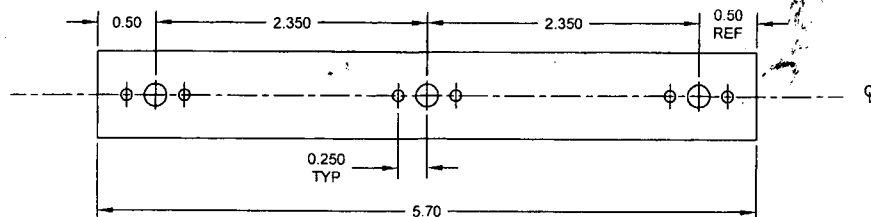
DRAWING NO. REV. A
D3880 SHEET 1 OF 3

TITLE SCALE
TAS TRAY MOUNT NTS

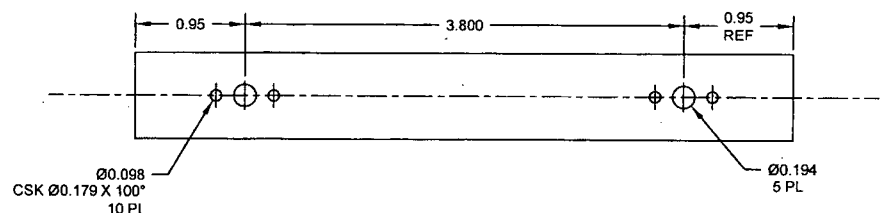
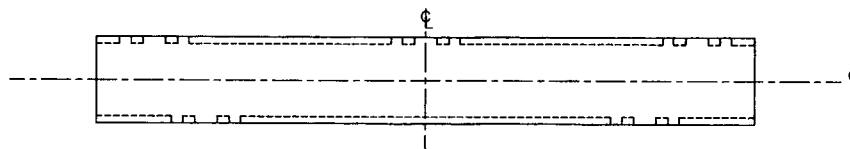
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51682

RELEASED
09/25/05/11/12



no
51682



D3880-1 SPACER

RELEASED
09/05/05

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SQUARE TUBING (0.75 X 0.75 X 0.063 WALL) PER AMS-QQ-A-200/8 (REF DART SPEC M6061T6TS0.750W.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	KB	DART AEROSPACE LTD	
DRAWN	KB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KB	DRAWING NO.	REV. A
MFG. APPR.	DD	D3880	SHEET 2 OF 3
APPROVED	DD	TITLE	SCALE
DE APPR.	DD	TAS TRAY MOUNT	NTS
DATE	09.01.22	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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